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D2353

Job Sheet 185894



Part No: D2353

Job Qty: 8 ea

Part Name: Stiffener



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/6/18

Job Tracking No:

Due Date: 11/27/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev: A Removed from 9 Digit 05-11-10 EC IPP: B 06.11.15 waterjet EC IPP: c 06.12.07 ecn 836 ec

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	8 pcs	11/27/18	11/27/18	0.00	0.50	Waterjet - Flow		SC 18/11/18
120	QC	8 pcs	11/27/18	11/27/18	0.00	0.00	QC8		38
130	Brake NC	8 pcs	11/27/18	11/27/18	0.02	0.30	Brake NC 1		DAS 38
140	QC	8 pcs	11/27/18	11/27/18	0.00	0.00	QC5		38
150	HandFinish	8 pcs	11/27/18	11/27/18	0.00	0.34	HandFinish1		DR 18/11/23
155	QC	8 pcs	11/27/18	11/27/18	0.00	0.00	QC7		BEB 18-11-26
160	Powdercoat	8 pcs	11/27/18	11/27/18	0.00	0.12	Powdercoat4		BEB 18-11-26
170	QC	8 pcs	11/27/18	11/27/18	0.00	0.00	QC3		38
180	Packaging	8 pcs	11/27/18	11/27/18	0.00	0.00	Packaging3	57225 A	NOV 29 2018
190	QC21-SA	8 Ea	11/27/18	11/27/18	0.00	0.00	QC21		21

Part Op 100 - 1-Cut as per Dwg D2353

Descriptions: 130 - Bend per Dwg D2353

1138539 160 - START TIME: 8:20

TEMP: 320°

FINISH: 8:50

NOV 29 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.050	2024-T3 .050 Sheet	1.1704 sf (.1463 ea)	100-Waterjet - Flow - 1	M15 10/26

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.050	1	39	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Stiffener	15.198Inches ± 0.010	15.208 15.188	15,200	
2	Stiffener	0.966Inches ± 0.005	0.971 0.961	0,965	
3	Stiffener	0.354Inches ± 0.010	0.364 0.344	0,357	
4	Stiffener	0.128Inches	0.133	0,130	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fah ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Re- ☐ Engineering ☐ Quality ☐ Other ☐		
Date : _____	Step #: _____	Part: D2353 Job No: 185894 Serial No/Batch: S127001 Container No: S127001 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's Date: 11/12/18		
Description Work Order Deviation				
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Conc ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		
OTHER : ☐		Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Wrong Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		

+ 0.005
- 0.000

0.128

Plex 11/6/18 11:31 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Large Fab ☐	Composite ☐	Supplier ☐																			

Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval
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Description Work Order Deviation	Disposition	Completed By
		Lead hand / Supervisor Approval Verification
		QC / QA Coordinator Approval

Root Cause			FAULT CATEGORY		
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				